

Split
Work Order ID 70820-2

Wednesday, June 15, 2011 2:27:53 PM

Page 1

Item ID: D3405-041

Accept

Revision ID:

Item Name: Lug Assembly

Start Date: 6/15/2011 Start Qty: 12.00

Required Date: 6/22/2011 Req'd Qty: 12.00

Reference:

Approvals: Process Plan:

Date: 6-15 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3405

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3405

304 .125

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

B11-6-16

(18)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-6-16

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/16

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Tooling:

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QC:

Date:

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Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

1-Debur

2-Form using DT8204 as per Dwg D3405

3-use DT9681 to check if correct forming

0.00

0.00

8/16/17

15

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/16/17

70

150



Large Fab

Large Fab

Large Fab

Memo

Weld as per Dwg D3405 use DT8484
Identify as D3405-041

0.00

0.00

2 11-7-18 X7

W/O:		WORK ORDER CHANGES					
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Work Order ID 70820

Wednesday, June 15, 2011 2:27:53 PM

Page 3

Item ID: D3405-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Lug Assembly

Start Date: 6/15/2011 Start Qty: 12.00

Required Date: 6/22/2011 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

6/11.07.14

7x

170

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

5/11/7/15

+7

180

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME:
OVEN TEMPERATURE:
FINISH TIME:

8:55
700
9:25

7

11-7-15

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Wednesday, June 15, 2011 2:27:53 PM

Page 4

Item ID: D3405-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Lug Assembly

Start Date: 6/15/2011 Start Qty: 12.00

Required Date: 6/22/2011 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: 478

0.00



Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

7 d H u l o + 15

Rec'd 15-07

11/7/18
MF
11-07-15

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Picklist Print

Wednesday, June 15, 2011 2:28:00 PM

Page 1

Work Order ID: 70820

Parent Item: D3405-041

Parent Item Name: Lug Assembly



Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP A 105.09.01 New issue KJ/JLM
IPP B 09.01.28 rev.B drawing EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3404-1



GHW Lug

Manufactured No

100 Each 35.0000 1 12



EL 11-7-14

Location

Loc Qty

Loc Code

WA

32

69883

32

WA030

3

67127

3

150 sf

127.0000

0.154

1.945263



FB1-6-16

M304S11GA

Purchased

No



304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT020

127

117494

127

117444

(15)

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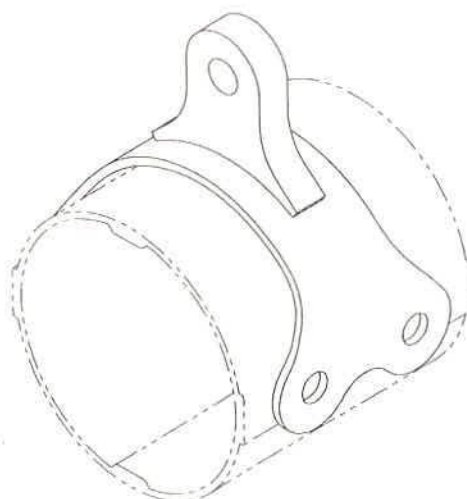
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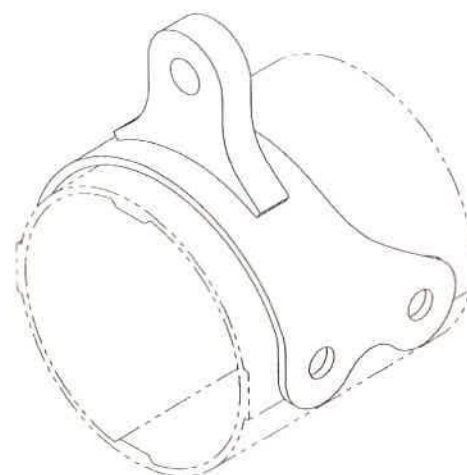
ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

(B)

RETURNED TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70320
MA 26 15



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

RELEASED
08/12/18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO 'B' SIZE BORDER FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198) SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100	AJS	08.09.19
A	NEW ISSUE	PH	05.03.08
REV	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	DRAWING NO.	REV. B
CHECKED		D3405	SHEET 1 OF 4
MFG. APPR.		TITLE	SCALE
APPROVED		GHW LUG ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT DART AEROSPACE LTD'S PERMISSION FROM DART AEROSPACE LTD	
DATE	08.09.19		

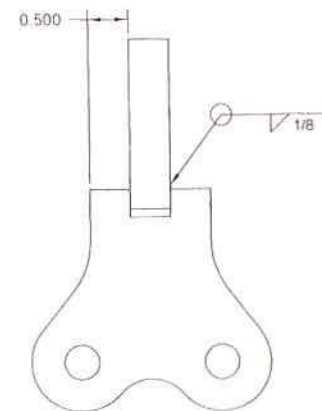
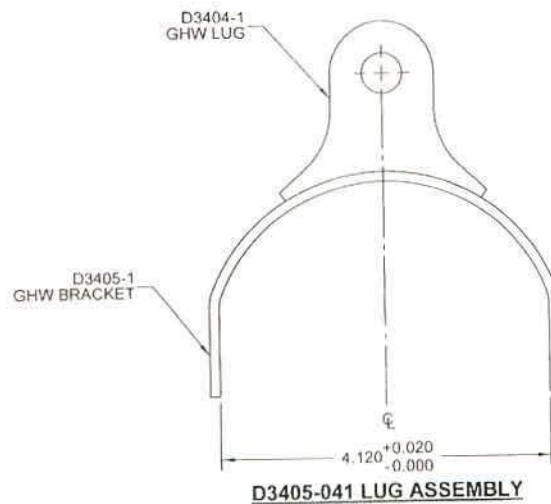
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

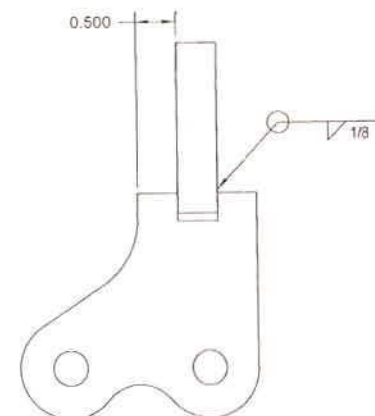
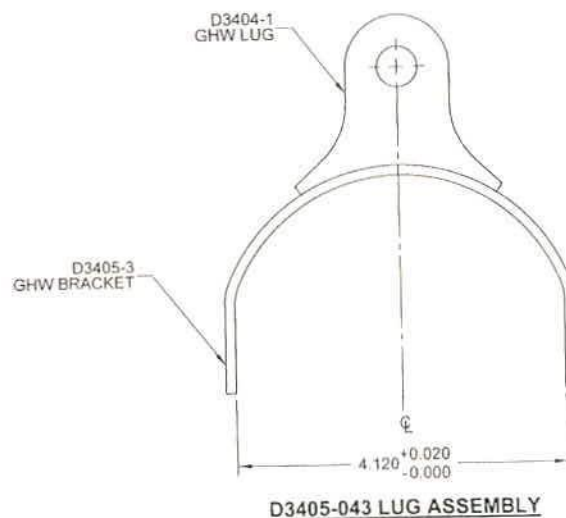
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NOTE: Date & initial all entries



u/o 70820



RELEASED
06/12/18 M/P

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3405	REV. B
MFG. APPR.		TITLE	SHEET 2 OF 4
APPROVED		SCALE	NTS
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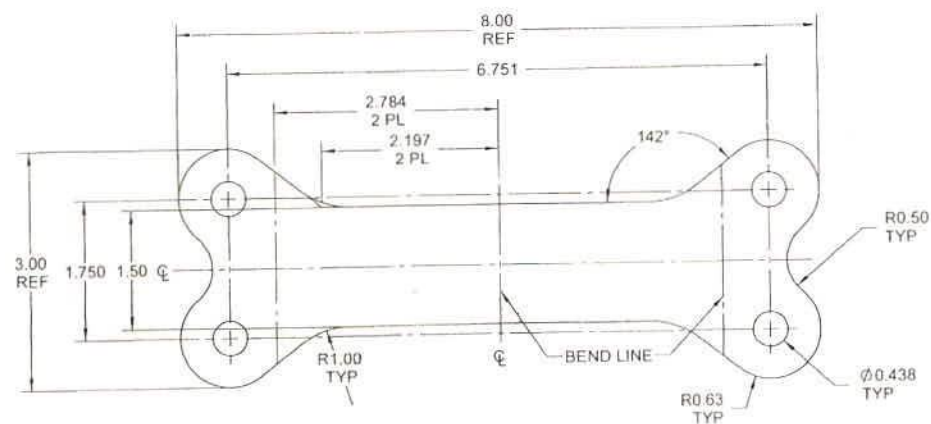
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

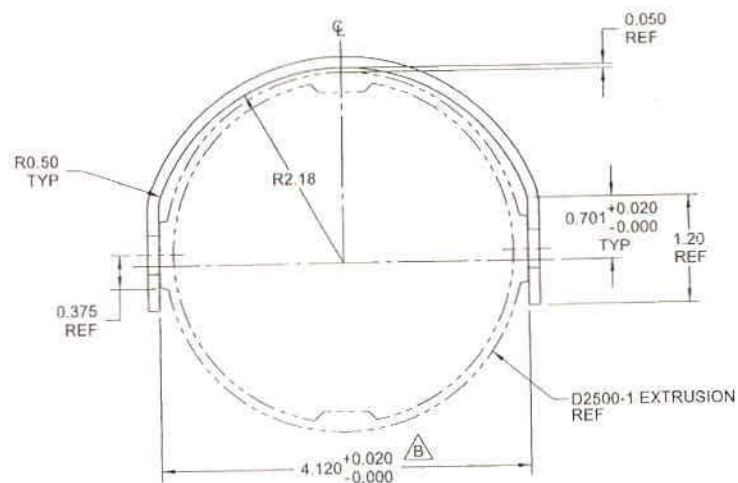
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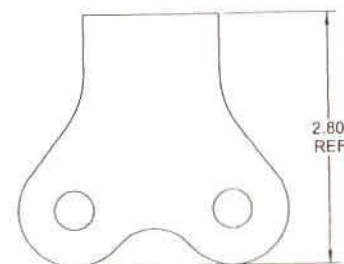
NOTE: Date & initial all entries



D3405-1F GHW BRACKET FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)



SIDE VIEW FOR REF ONLY

- NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	ABS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
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08/09/19

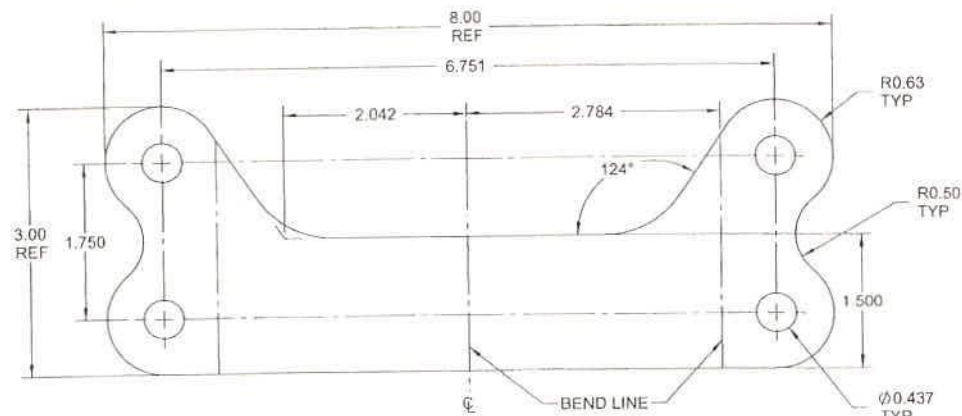
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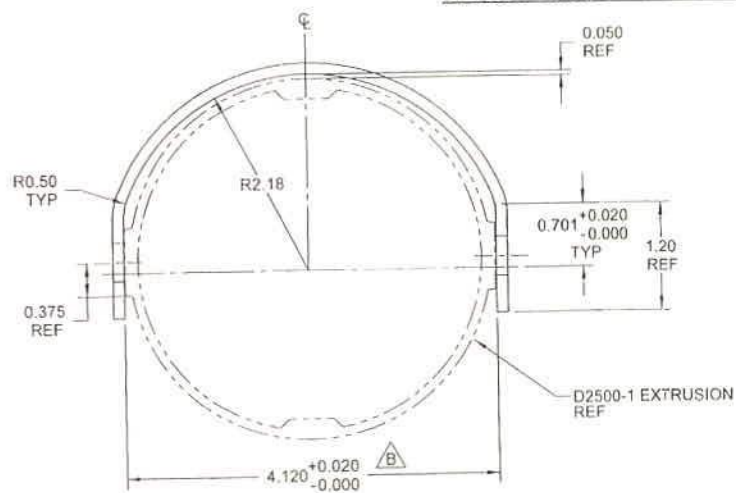
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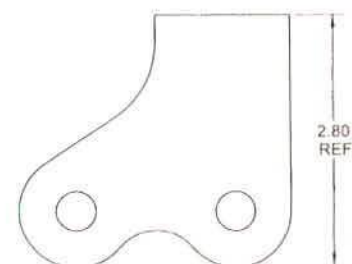
NOTE: Date & initial all entries



D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 4 OF 4
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RELEASED
06/12/14

W/O:		WORK ORDER CHANGES					
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